**INTRODUCTION**

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| The YASNAC MX1 is a high-performance CNC for simultaneously controlling 3 or 4 axes of a machin- ing center, with emphasis placed on high -speed machining, unattended automatic operation, or feedback gauging control.  With the NC logic incorporating 16-bit micropro- cessors and various LSIs, the YASNAC MX1 in- corporates a compact design with a wide range of capabilities. The memory comprises permanent, semi-permanent and programmable software storage used in combination to utilize each one to maximum advantage.  The data input-output interface has been expanded in concept, and, in addition to conventional | interfaces such as FACIT and RS 232C, RS 422 is now available to accommodate requirements for new modes of operations such as high-speed, long-distance data transmission.  The YASNAC can incorporate a programmable machine interface, and the logic diagram can be edited easily from the NC operator's station. |

**2. PROGRMMING**

**2.1 INPUT FORMAT**

**2.1.1 INPUT FORMAT**

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| A variable block format conforming to JIS#B 6313 is used for YASNAC MX1. | Table 2.1 shows the input format. Numerals following the address characters in Table 2.1 indicate the programmable number of digits. |



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| Note:  A decimal point should be omitted in actual pro- gramming when you make a program including decimal points, refer to 2.1.3 DECIMAL POINT PROGRAMMING.  The leading zeros can be suppressed for all ad- dress codes. Plus signs need not be programmed, but all minus signs must be programmed.  ln the manual, EOB (end of block) code in a pro- gram example is represented by a semicolon (;). in actual programming, CR (E1A code) or LF/NL (ISO code) should be used instead of the semicolon (;). | * Metric input format   04 N4 G3 a+43 F5 S2 T2 M3 D(H)2 B3;   * Inch input format   04 N4 G3 a+34 F31 S2 T2 M3 D(H)2 B3;  Notes:   * “a” represents X, Y, Z, I, J or K. * P. Q. R and L are omitted in the above format because they are used for various meanings   # Japanese Industrial Standard |

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